



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D4016-3
Job Sheet 196680



Part No: D4016-3

Job Qty: 30 pcs

Part Name: Hinge Half, Lid



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/19/19

Job Tracking No:

Due Date: 6/26/19

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV B SHEET 2 I[PP REV:A NEW ISSUE 09-11-27 JL VERIFIED BY:DD IPP Rev:B as per dwg REV.A
DD 10.02.22 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
150	Bandsaw - 1	30 pcs	6/26/19	6/26/19	0.00	1.16	Bandsaw - 1	JLK 19/06/23 DTP 19/06/26
160	HAAS 4 Axis - B4B	30 pcs	6/26/19	6/26/19	0.09	11.03	HAAS - 1 - B4B	
							HAAS - 2 - B4B	
							HAAS - 3 - B4B	
							HAAS - 4 - B4B	
180	QC 8	30 pcs	6/26/19	6/26/19	0.00	0.00	QC 8 - 12	JL 19-06-26
							QC 8 - 14	
							QC 8 - 17	
							QC 8 - 20	
							QC 8 - 25	
							QC 8 - 3	
							QC 8 - 32	
							QC 8 - 33	
							QC 8 - 35	
							QC 8 - 39	
							QC 8 - 4	
							QC 8 - 44	
							QC 8 - 45	
							QC 8 - 49	
							QC 8 - 58	
							QC 8 - 8	
							QC 8 - 9	
							QC 8 - 68	
							QC 8 - 67	
							QC 8 - 1 (A)	
							QC 8 - 47	
							QC 8 - 40	
							QC 8 - 52	
							QC 8 - 23	
							QC 8 - 57	



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Container No: S193147



Part: D4016-3

Job No: 196680

Serial No/Batch: S193147

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 06/24/19

190 Packaging 3-1 - Stock - B4B 30 pcs

6/26/19

0.00 0.00

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 - B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 - B4B

Packaging 3 - 13 - B4B

Packaging 3 - 14 - B4B

Packaging 3 - 15 - B4B

Packaging 3 - 16 - B4B

Packaging 3 - 17 - B4B

Packaging 3 - 18 - B4B

Packaging 3 - 19 - B4B

Packaging 3 - 20 - B4B

Packaging 3 - 21 - B4B

Packaging 3 - 22 - B4B

Packaging 3 - 23 - B4B

Packaging 3 - 24 - B4B

Packaging 3 - 25 - B4B

Packaging 3 - 26 - B4B

Packaging 3 - 27 - B4B

Packaging 3 - 28 - B4B

Packaging 3 - 29 - B4B

Packaging 3 - 30 - B4B

Packaging 3 - 31 - B4B

Packaging 3 - 32 - B4B

Packaging 3 - 33 - B4B

Packaging 3 - 34 - B4B

Packaging 3 - 35 - B4B

Packaging 3 - 36 - B4B

DAS

74

9-89

JUN 27 2019

200 QC 21 - SA

30 pcs

6/26/19

0.00 0.00

QC 21 - SA - 21

QC 21 - SA - 70

QC 21 - SA - 53

JUN 28 2019

DAS

70

9-89

Part Op 150 - CUT BLANK as per folio

Descriptions: 160 - (HAAS CNC Vertical Machine), MACHINE AS PER FOLIO FA874 AND DWG

180 - (QC8- Inspect parts - second check)

190 - (Identify as per dwg & Stock Location: _____), LOCATION: WA004-6

200 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item

M304B1.000X1.000

Component Name

304 Bar 1.00 X 1.00

Quantity

2.4000 ft (.08 ea)

Operation

150-Bandsaw - 1

Container

S 151464

S 190197 3.90

34 = 2.720 ft

Job Allocations

Operation

150-Bandsaw - 1

Component Part

M304B1.000X1.000

Required

2

Inventory

40

Allocated

0

Bom => 2.400 ft

used => 2.720 ft

Scrap => 0.320 ft Scrap

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Hinge Half, Lid	0.880Inches ± 0.030	0.910 0.850	0.884	
2	Hinge Half, Lid	0.130Inches ± 0.030	0.160 0.100	0.138	
3	Hinge Half, Lid	0.250Inches ± 0.010	0.260 0.240	0.250	
4	Hinge Half, Lid	0.030Inches ± 0.030	0.060 0.000	0.030	Radius
5	Hinge Half, Lid	0.130Inches ± 0.030	0.160 0.100	0.134	
6	Hinge Half, Lid	0.500Inches ± 0.030	0.530 0.470	0.504	
7	Hinge Half, Lid	0.630Inches ± 0.030	0.660 0.600	0.628	
8	Hinge Half, Lid	0.563Inches ± 0.010	0.573 0.553	0.568	
9	Hinge Half, Lid	0.257Inches + 0.006 - 0.001	0.263 0.256	0.257	Diameter

DAS
73
9-89

Plex 6/19/19 9:36 AM dart.lacelle.linda